

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-004767**Date Inspected:** 06-Nov-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1330**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2230**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Liu Wei Wei**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Fabrication**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Mr. Paul Dawson, arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China, for the purpose of monitoring welding and fabrication of the San Francisco / Oakland Bay Bridge (SFOBB) components. The QA Inspector observed the following:

OBG Bay #3

The QA Inspector performed random AWS D1.5 visual and ultrasonic inspections of the following OBG component welds as listed on the ZPMC Notification of Witness Inspection document #1360:

BP094-001-067, BP121-001-067, BP175-001-067; The QA Inspector performed ultrasonic inspections of this weld and the weld appears to comply with project specifications. For additional information on these inspections see the TL6027 Ultrasonic Test Report.

BP067-001-067; The QA Inspector observed ZPMC Ultrasonic Inspectors have identified this weld as having portions of the weld as having an ultrasonic rejection.

BP121-001-067, BP175-001-067, BP067-001-067; The QA Inspector marked 300 mm length of these welds as needing to be inspected using the radiographic technique. Later in the shift the QA Inspector observed ZPMC has ground the welds flush in the areas that had been marked.

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OBG Bay 7 and 8

The QA Inspector performed random AWS D1.5 visual and ultrasonic inspections of the following OBG component welds as listed on the ZPMC Notification of Witness Inspection document #1358:

FB004-020-043, FB005-025-043 and -044, FB004-018-043 and -044, FB013-020-043 and 044, FB059-004-095 and -096, FB065-001-016 and -017, FB072-001-006 and 007, FB003-001-004 and FB003-110-005; The QA Inspector performed ultrasonic inspections of these welds and the welds appear to comply with project specifications. For additional information on these inspections see the TL6027 Ultrasonic Test Report.

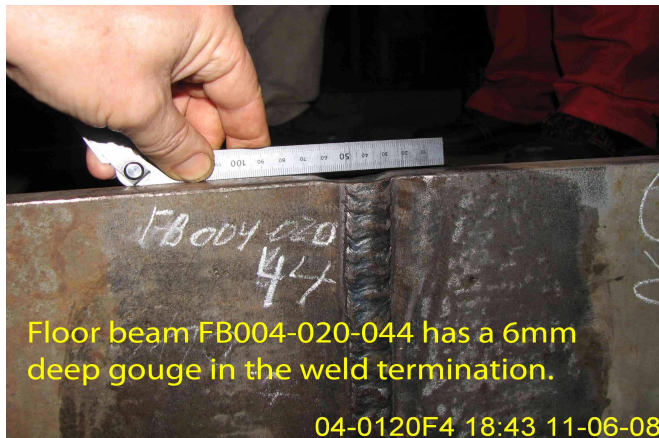
The following welds do not appear to have been ultrasonically inspected by QA personnel and the QA Inspector performed random visual and ultrasonic inspections of the following welds today:

FB014-007-043, FB064-002-007 and FB064-002-016, FB072-001-007, FB072-001-016, FB056-001-006, FB055-003-006 and FB055-003-023, FB013-015-043 and FB013-015-044, FB071-001-016, FB003-110-004 and FB003-110-005; The QA Inspector performed random visual and ultrasonic inspections of these welds and the welds appear to comply with project specifications. For additional information on these inspections see the TL6027 Ultrasonic Test Report.

FB056-001-023; The QA Inspector performed ultrasonic inspections of this weld and the weld appears to have a class "A" (Reject) indication. The QA Inspector informed CWI Mr. Liu Wei Wei who said he will have ZPMC ultrasonic inspectors reinspect this weld. For additional information on these inspections see the TL6027 Ultrasonic Test Report.

The QA Inspector observed Floor Beam weld FB071-001-007 has a 4mm deep gouge in the bottom termination (end) of this CJP weld. The QA Inspector informed CWI Mr. Liu Wei Wei who said he will have ZPMC add weld to the portions of the weld that is below flush.

The QA Inspector observed Floor Beam weld FB004-020-044 has a 6mm deep gouge in the top termination (end) of this CJP weld. The QA Inspector informed CWI Mr. Liu Wei Wei who said he will have ZPMC add weld to the portions of the weld that is below flush. See the photograph below for additional information.



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Summary of Conversations:

See above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Ady Velasco 13816942685, who represents the Office of Structural Materials for your project.

Inspected By:	Dawson,Paul	Quality Assurance Inspector
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Reviewed By:	Carreon,Albert	QA Reviewer
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